

# Work Order ID 90296

\*90296\*

Page 1

September-17-12 8:52:00 AM

Item ID: D3065-041 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Step Leg Assembly Hi  
 Start Date: 9/17/12 Start Qty: 20.00 \*20\* Cust Item ID:  
 Required Date: 10/12/12 Req'd Qty: 20.00 \*20\* Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12-09-17 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3065	Rev B								
100		0.00							
<b>*100*</b>	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg D3065 and Identify as D3065-041								
110		0.00							
<b>*110*</b>	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
120		0.00							
<b>*120*</b>	Identify as per dwg & Stock Location: <u>W14</u>								
Packaging	Memo	0.00							
Packaging									

20x 12/11/17

20 12/11/22 23 89 DA SB

20 12/11/22

**Work Order ID 90296**

September-17-12 8:52:00 AM

**\*90296\***

Page 2

Item ID: D3065-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Step Leg Assembly Hi

Start Date: 9/17/12 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 10/12/12 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									

12/11/22 *[Signature]*  
ME  
12-11-22

# Picklist Print

September-17-12 8:51:59 AM

Page 1  
/2

Work Order ID: 90296

Parent Item: D3065-041

Parent Item Name: Step Leg Assembly Hi

Start Date: 9/17/12

Required Date: 10/12/12

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev: C02.11.01 Incorporated D3066-1 IPPKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3065-1 Step Spacer		Manufactured	No			100	Each	71.0000	1	20		9/12/11/15	

Location	Loc Qty	Loc Code
GA	71	
74497	1	
81303	1	
83733	30	
85469	39	

D3065-3 Step Spacer		Manufactured	No			100	Each	72.0000	1	20		9/12/11/15	
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Location	Loc Qty	Loc Code
GA	72	
69827	1	
73290	4	
75152	14	
83734	12	
83873	1	
85470	40	

D3065-5 Step Leg		Manufactured	No			100	Each	200.0000	2	40		9/12/11/15	
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Location	Loc Qty	Loc Code
GA	200	
67222	1	
73289	19	
85462	60	
88827	80	
89239	40	

B88825 (192)  
B90766 (1K)  
B89939 (3K)  
B89938 (17K)  
B90073 (40K)

# Picklist Print

September-17-12 8:51:59 AM

Page 2

Work Order ID: 90296  
 Parent Item: D3065-041  
 Parent Item Name: Step Leg Assembly Hi

Start Date: 9/17/12 Required Date: 10/12/12  
 Start Qty: 20.00 Required Qty: 20.00

D3065-7 Manufactured No

100 Each 61.0000 1 20

Step Spacer

Location	Loc Qty	Loc Code
GA	61	
73291	7	
74499	1	
78666	4	
83738	1	
83875	9	
85471	39	

*[Signature]*  
 9/21/14

B 90705 (124)  
 B 90520 (82)

MS20470AD4-4 Purchased No

100 Each 7.607.0000 30 600

Rivet, Universal Head

Location	Loc Qty	Loc Code
ST313	2662	
122027	2600	
122063	62	
ST319	4945	
116188	136	
116391	66	
118614	912	
119109	26	
121011	5	
121556	800	
121652	3000	

*[Signature]*  
 9/21/14

M123352  
 (6000)

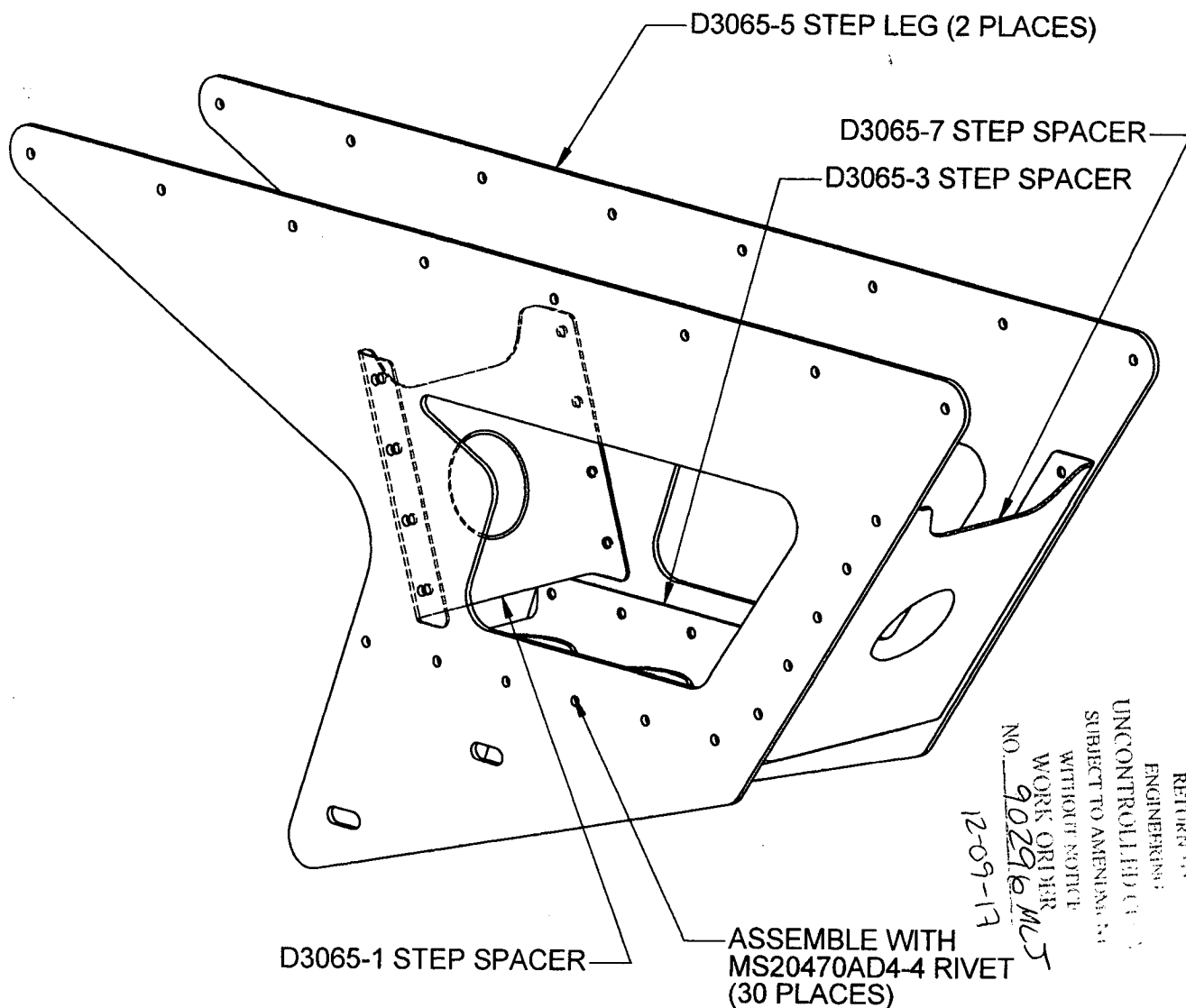
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Shop Packet Print

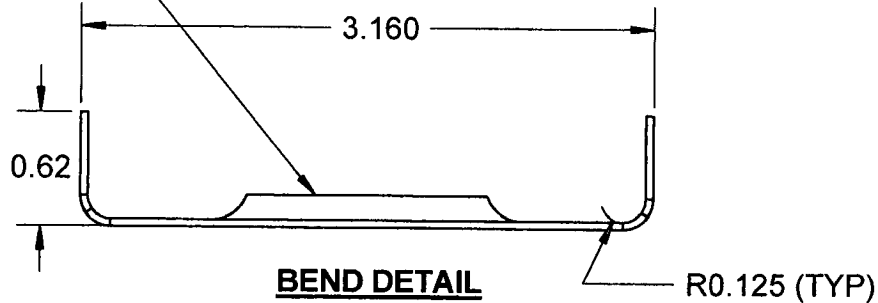
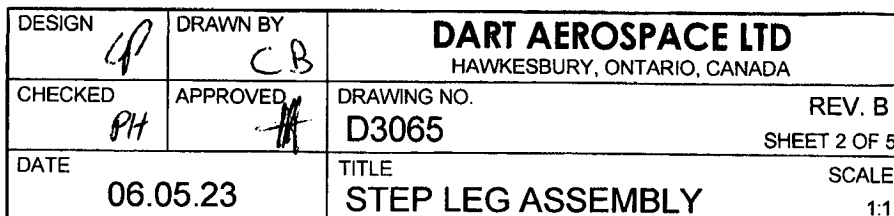
Page 2

**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3065</b>	REV. B SHEET 1 OF 5
DATE <b>06.05.23</b>		TITLE <b>STEP LEG ASSEMBLY</b>	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

**RELEASED***06.06.20 [Signature]***D3065-041 STEP LEG ASSEMBLY****COPYRIGHT © 2002 BY DART AEROSPACE LTD.**

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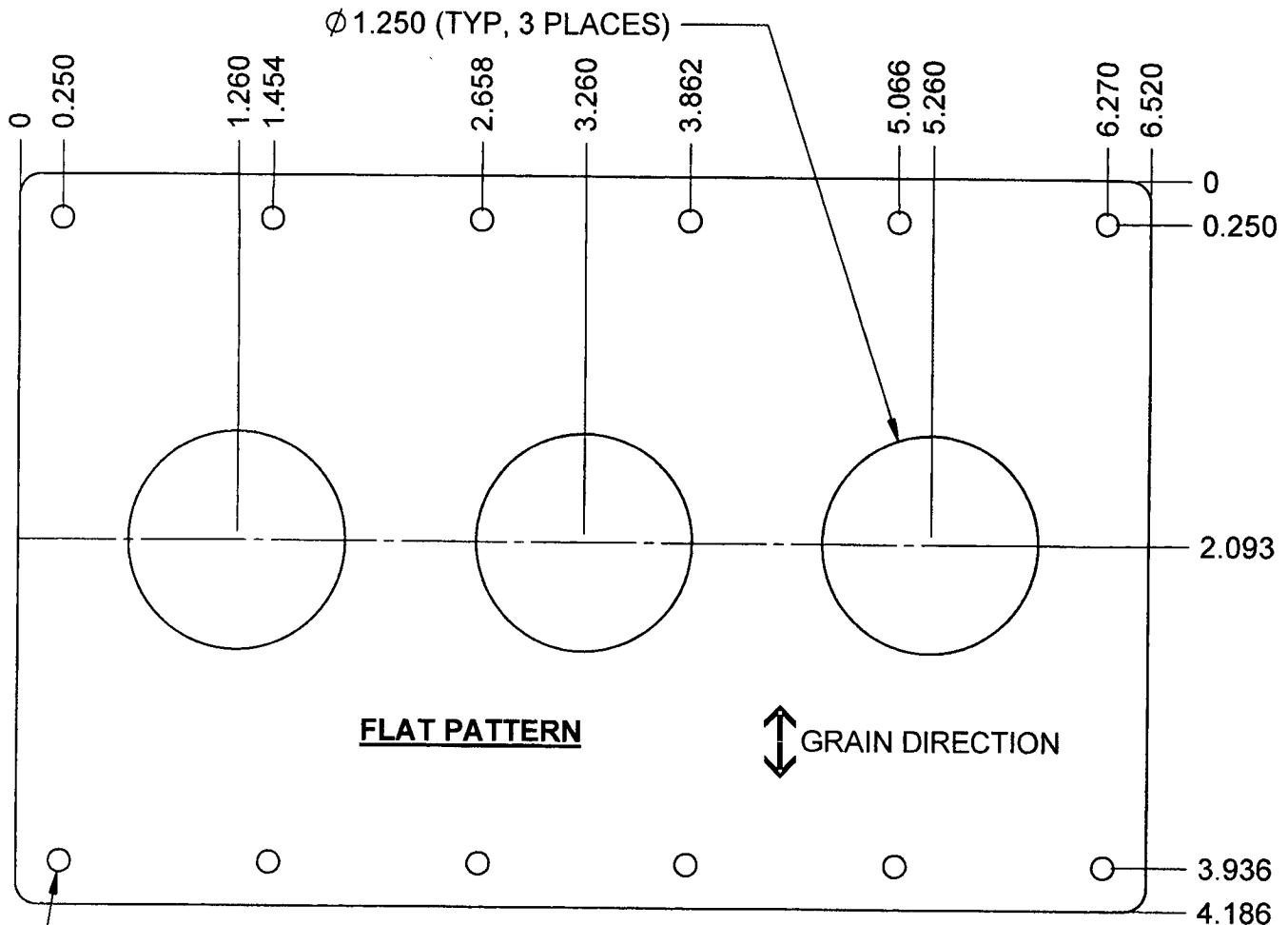
1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)  
2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1  
3) BREAK ALL SHARP EDGES 0.005 TO 0.010  
4) PART IS SYMMETRIC ABOUT CENTERLINE  
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
6) ALL DIMENSIONS ARE IN INCHES

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90296



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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3065</b>	REV. B
DATE <b>06.05.23</b>	TITLE <b>STEP LEG ASSEMBLY</b>		SHEET 3 OF 5 SCALE 1:1

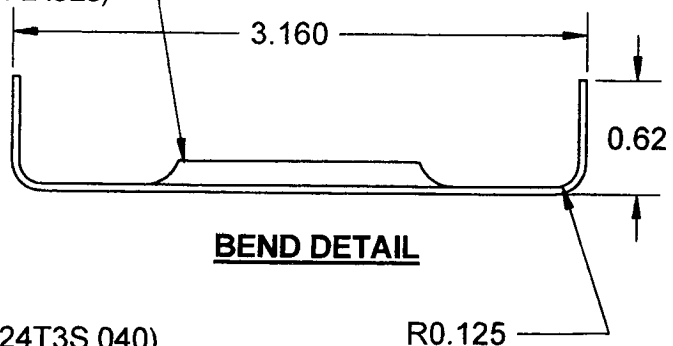


FLANGE AFTER TOWARDS SIDE  
SHOWN USING DT8174 (3 PLACES)

Ø 0.129 (TYP, 12 PLACES)

**RELEASED**

*06 06 20* *[Signature]*



### **D3065-3 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)  
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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# DART

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Dec 20 - 74



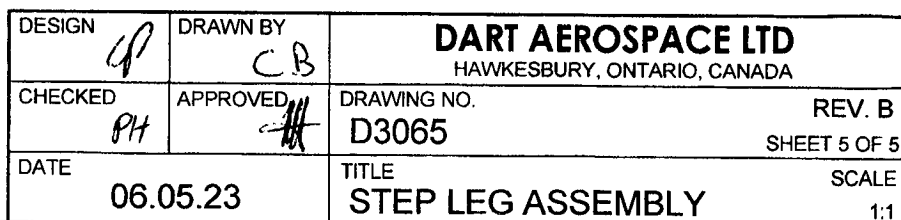
- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"  
 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK  
 (REF DART SPEC M6061T6S.080)  
 OR  
 5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)  
 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1  
 4) BREAK ALL SHARP EDGES 0.005 TO 0.010  
 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
 6) ALL DIMENSIONS ARE IN INCHES

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## FLAT PATTERN

**RELEASED**

06 06 20

0.62

### BEND DETAIL

R0.125 (TYP)

### D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)  
2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1  
3) PART IS SYMMETRIC ABOUT CENTERLINE  
4) BREAK ALL SHARP EDGES 0.005 TO 0.010  
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
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